



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEA62309
Job Sheet 193143



Part No: RBEA62309

Job Qty: 1 pcs

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62309 rev.T IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP/IPP Rev.B 19.02.28 drawing revision
DP Verify DD/IPP Rev. C 19.04.01 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Issue SN	1 pcs	5/6/19	0.00	0.00		Small Fab - 1		MCC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
105	Small Fab - 2 - B4B	1 pcs	5/6/19	0.00	1.00		Small Fab - 1 - B4B		MCC
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	1 pcs	5/6/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		

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CANADA
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Container No: S191640



Part: RBEA62309

Job No: 193143

Serial No/Batch: S191640

Revision: T

Inspector:

Exp Date:

Instructions:

Date: 06/19/19

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4/9/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

DAS
40
9-89

JUN 20 2019

				QC 5 - 40	
130	Packaging 3-1 - Stock - B4B	1 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - FG	1 pcs	5/6/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Dart

DAS
21
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JUN 21 2019

RB001A

Part Op 100 - Issue S/N.

Descriptions: 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1750-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Add 5090 834 (Inclinometer)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1750-E	Pelican Case 1750	1 Ea (1 ea)	100-Small Fab - Issue SN	5180612
5274T761 48-49	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5142197
7189K31 45	Cable Ties Black	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5038430
30 9052000	10" Mini Bungee Cord	4 Ea (4 ea)	105-Small Fab - 2 - B4B	5094606
25 97524A032	Sealing Blind Rivet	4 Ea (4 ea)	105-Small Fab - 2 - B4B	5163934
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5183173
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5021040
144B RBE-350DAMPER	Damper Spanner Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5177621
144A RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5162451
143B RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5180634
72 RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5129866
144A RBE-350TEMP	Temperature Probe	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186244
143 RBE350A93-3200-20-1	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5115438
RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5168976
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5168994
RBE350A93-3300-20	Tail Rotor Hub Socket	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5167911
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	518626
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5191505
RBE350A93-3305-20-1	Tail Gearbox Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5120027
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5182513
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186550
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5160539
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5172722
RBE350A93-3400-00	Drive Shaft Thimble	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5115898
RBE350A93-3500-00	Bearing Extractor	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186607
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5122684
RBE350A94-2704-00	Pedals Locking Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186633
RBE350A94-2706-00	Rigging Pin Set	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186659
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5191362
RBE350A94-3301-00	Tail Rotor Accelerator Support	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5113375
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5187059
RBE350A94-3700-B	Swashplate Immobilizing Tool, Short Brace Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5187856
RBE350A94-3700-C	Swashplate Immobilizing Tools Adjustable Brace	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5183103
RBE350A94-3701-00	7" Main Rotor Rigging Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5187514
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5178016
RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5168458
RBE703A95-0505-00-15	TGB Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5191040
RBE703A95-0508-00-15	MGB Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5181864
RBE703A95-0508-00-17	MGB Drain Tube Hose Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5159423
RBE703A95-0520-01-17	Engine & Hydraulic Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5159424
RBE703A95-0520-01-19	Engine & Hydraulic Drain Tube Hose Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5180609
RBEA62309-2	Bottom Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5189245
RBEA62309-3	Stiffener Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5190610
RBEA62309-6	Top Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5180611
RBEA62309-7	Top Foam Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5191857
RBEA62309-8	Top Shelf Placard	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5179694
RBEA62309-9	Bottom Shelf Placard	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5183183
RBEA62310	AS350/355 Engine Strut	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5131169
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5170554
RBW109-3101-58-1-1	Hammer, Steel	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5154677
RBW109-3101-58-2-1	Hammer, Aluminum	1 pcs (1 ea)	105-Small Fab - 2 - B4B	

5115959
5151532

76

76
76

102

510480

RBE703A94-1130-01-01

RBE703A94-1130-01-23

Qty 1 5187057

Qty 1

5142166

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Issue SN	APP-1750-E	1	10	0
105-Small Fab - 2 - B4B	5274T761	1	25	0
	7189K31	1	761	0
	9052000	4	75	0
	97524A032	4	349	0
	NAS1756-12	1	235	0
	RB41011	1	352	0
	RBE-350DAMPER	1	5	0
	RBE-350HYD	1	14	0
	RBE-350INCLINOMETER	1	21	0
	RBE-350TDRS	1	21	0
	RBE-350TEMP	1	7	0
	RBE350A93-3200-20-1	1	17	0
	RBE350A93-3205-00E	1	11	0
	RBE350A93-3205-00T	1	12	0
	RBE350A93-3300-20	1	16	0
	RBE350A93-3302-02	1	2	0
	RBE350A93-3303-02	1	3	0
	RBE350A93-3305-20-1	1	11	0
	RBE350A93-3307-00	1	3	0
	RBE350A93-3312-03	1	7	0
	RBE350A93-3316-20-1	1	23	0
	RBE350A93-3317-20	1	7	0
	RBE350A93-3400-00	1	43	0
	RBE350A93-3500-00	1	7	0
	RBE350A93-3501-20	1	14	0
	RBE350A94-2704-00	1	8	0
	RBE350A94-2706-00	1	7	0
	RBE350A94-2708-01	1	5	0
	RBE350A94-3301-00	1	10	0
	RBE350A94-3700-A	1	7	0
	RBE350A94-3700-B	1	0	0
	RBE350A94-3700-C	1	5	0
	RBE350A94-3701-00	1	13	0
	RBE350A94-5201-20	1	8	0
	RBE703A94-1130-01	1	2	0
	RBE703A95-0505-00-15	1	5	0
	RBE703A95-0508-00-15	1	4	0
	RBE703A95-0508-00-17	1	4	0
	RBE703A95-0520-01-17	1	14	0
	RBE703A95-0520-01-19	1	10	0
	RBEA62309-2	1	12	0
	RBEA62309-3	1	6	0
	RBEA62309-6	1	12	0
	RBEA62309-7	1	12	0
	RBEA62309-8	1	22	0
	RBEA62309-9	1	7	0
	RBEA62310	1	3	0
	RBT18025-13	1	15	0
	RBW109-3101-58-1-1	1	10	0
	RBW109-3101-58-2-1	1	10	0

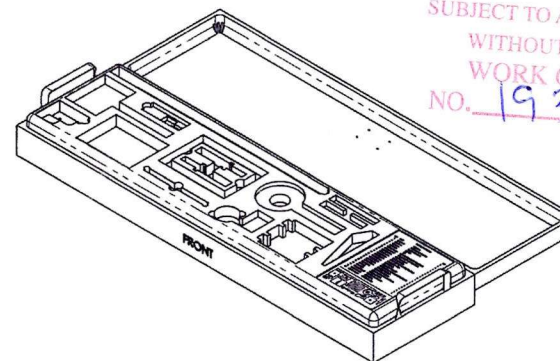
Part Specifications

Specifications could not be found.

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SHOP COPY

RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193143
19-04-09**RBEA62309 AS350/355 FIELD MAINTENANCE KIT**

T	REPLACED ITEM -5 WITH DTSP10002 ITEM 58 WAS McMaster#97447A651 OR EQUIV. IS McMaster#97484A341 OR EQUIV. -2 DIM WAS 3.50 REF IS 3.29 -4 DIM WAS ϕ 0.261/0.257 THRU IS ϕ 0.257 THRU -6 DIM WAS 1.63 REF IS 1.63	19-666	KPT
S	SEE PREVIOUS REVISIONS FOR MORE INFORMATION ITEM -10 WAS ITEM -9 ITEM -11 WAS ITEM -10 ITEM -12 WAS ITEM -11 ITEM -13 WAS ITEM -12 UPDATED BOM TO REFERENCE CORRECT TOOL NUMBERS TO BE INCLUDED IN KIT -5 ADDED HEAT CUT NOTE -8 ENGRAVING FOR BOTTOM SHELF REMOVED. UPDATED ENGRAVING -9 IS BOTTOM SHELF PLACARD. -10 P/N WAS McMaster#8835T93 (ELASTIC TIE DOWN) OR EQUIV. IS HIGHLAND#9052000 (ELASTIC TIE DOWN) OR EQUIV.	19-600	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT	TOOL PART # RBEA62309	
CHECKED	KPT	REV. T	
MFG. APPR.	DP	SHEET 1 OF 11	
APPROVED	WJP	TITLE AS350/355 FIELD MAINTENANCE KIT	
DATE 3/27/2019		SCALE NTS	
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

ITEM #	QTY	PART #	PART TITLE
-1	1	RBEA62309-1	PACKAGING ASSEMBLY
-8	1	RBEA62309-8	TOP SHELF PLACARD
-9	1	RBEA62309-9	BOTTOM SHELF PLACARD
-10	4	RBEA62309-10	HIGHLAND#9052000 OR EQUIV. (BUNGEE CORD 1/4" DIA. X 10" LG.)
-11	1	RBEA62309-11	NAS 1756-12 (REMOVE BEFORE FLIGHT FLAG)
-12	1	RBEA62309-12	McMaster#7189K31 OR EQUIV. (NYLON CABLE TIES 5-1/2" LG. X 1-1/8" MAX. BUNDLE DIA.)
-13	1	RBEA62309-13	McMaster#5274T761 OR EQUIV. (PLASTIC VIAL 2" DIA. X 1-5/8" HT.)
14	1	RBE350A93-3200-20	MGB/ROTOR BRAKE RETAINING NUT WRENCH
15	1	RBE350A93-3205-00E	ENGINE G/B INPUT FLANGE HOLDING WRENCH
16	1	RBE350A93-3205-00T	T/R G/B INPUT FLANGE HOLDING WRENCH
17	1	RBE350A93-3300-20	T/R HUB SOCKET
18	1	RBE350A93-3302-02	T/R HUB LOCK WRENCH
19	1	RBE350A93-3303-02	T/R BODY EXTRACTOR TOOL
20	1	RBE350A93-3305-20	TAIL GEARBOX WRENCH
21	1	RBE350A93-3307-00	TAIL GEARBOX SEAL EXTRACTOR
22	1	RBE350A93-3312-03	T/R HUB BUSHING REPLACEMENT TOOL
23	1	RBE350A93-3316-20	ROTATING STAR REPLACEMENT WRENCH
24	1	RBE350A93-3317-20	TAIL ROTOR HUB INSERT TOOL
25	1	RBE350A93-3400-00	DRIVE SHAFT THIMBLE
26	1	RBE350A93-3500-00	BEARING EXTRACTOR
27	1	RBE350A93-3501-20	EXTRACTION TOOL HYD. PUMP PULLEY BEARING
28	1	RBE350A94-2704-00	JAMMING TOOL, PEDALS
29	1	RBE350A94-2706-00	RIGGING PIN SET
30	1	RBE350A94-2708-01	T/R BLADE LOCK FIXTURE
31	1	RBE350A94-3301-00	T/R ACCELERATOR SUPPORT
32	1	RBE350A94-3700-A	SWASHPLATE IMMOBILIZING TOOL LONG BRACE
33	1	RBE350A94-3700-B	SWASHPLATE IMMOBILIZING TOOL SHORT BRACE
34	1	RBE350A94-3700-C	SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE
35	1	RBE350A94-3701-00	M/R RIGGING TOOL
36	1	RBE350A94-5201-20	CARTRIDGE, DUMMY, FUEL
37	1	RBE-350DAMPER	DAMPER SPANNER WRENCH
38	1	RBE-350HYD	HYDRAULIC ACCUMULATOR FITTING GAUGE
39	1	RBE-350INCLINOMETER	INCLINOMETER
40	1	RBE-350TEMP	TEMPERATURE PROBE
41	1	RBE-350TRDS	T/R DRIVESHAFT BEARINGS RUN OUT GAUGE
42	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSEMBLY
43	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSEMBLY
44	1	RBE703A95-0505-00-15	TGB DRAIN TUBE QUILL ASSEMBLY
45	1	RBE703A95-0508-00-15	MGB DRAIN TUBE QUILL ASSEMBLY
46	1	RBE703A95-0508-00-17	MGB DRAIN TUBE HOSE ASSEMBLY
47	1	RBE703A95-0520-01-17	ENGINE & HYDRAULIC DRAIN TUBE QUILL ASSEMBLY
48	1	RBE703A95-0520-01-19	ENGINE & HYDRAULIC DRAIN TUBE HOSE ASSEMBLY
49	1	RBEA62310	AS350/355 ENGINE STRUT
50	1	RBT18025-13	LINEAR SCALE
51	1	RBW109-3101-58-1-1	HAMMER, STEEL
52	1	RBW109-3101-58-2-1	HAMMER, ALUMINUM
53	1	RB41011	DART PLACARD
54	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

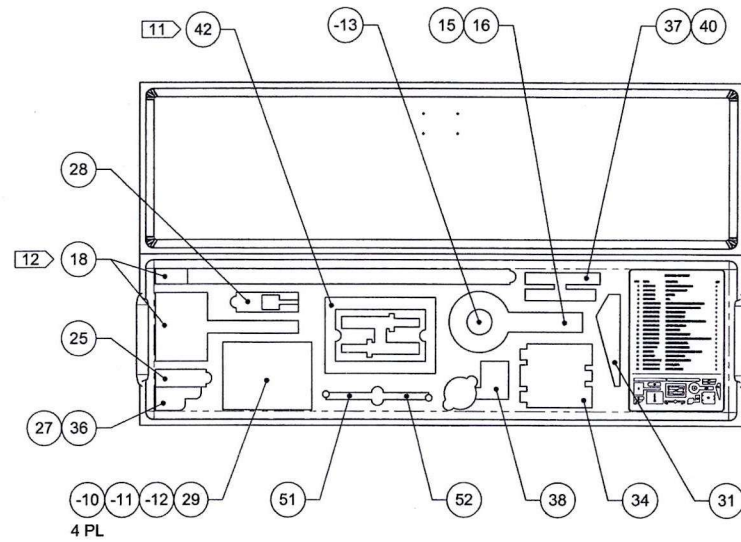
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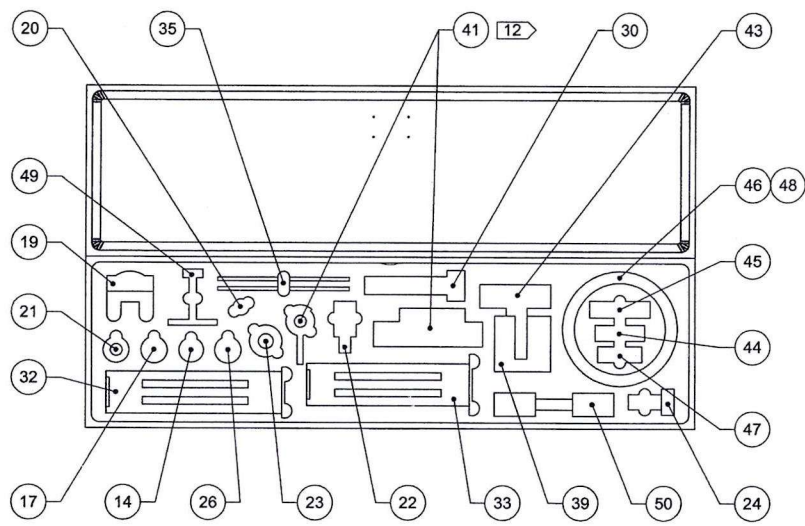
C

B

A



TOOLS PLACED IN ITEM -6 TOP FOAM



TOOLS PLACED IN ITEM -2 BOTTOM FOAM

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBEA62309 TITLE AS350/355 FIELD MAINTENANCE KIT COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. T
DRAWN	KPT		SHEET 3 OF 11
CHECKED	KPT		SCALE
MFG. APPR.	DP		NTS
APPROVED	<i>[Signature]</i>		
DATE	3/27/2019		

8 7 6 5 4 3 2 1